Work Order ID 71978 Thursday, July 14, 2011, 3:11:44 PM

Quality Control



Page 1

Inursaay, July 1	4, 2011 3:11:4	4 PM -											
	D3531-3	. 1		Accept					Setup	Start			
Revision ID: Item Name:	Bracket Front Pla	ate III								Stop			
Start Date:	7/14/2011	Start Qty: 500			Cust Item I	D:							
Required Date:	7/22/2011	Req'd Qty: 6.00			Customer:								
Reference:		3,											
Approvals:	Process Plan:		Date://-07-14		D:	ate:			Run	Start Stop			
	QC:	- (Date:	SPC (Y/N):	D:	ate:				отор			
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revisi	on Nbr											_
D3531	Rev A										•		
100 Waterjet	F	LOW WATER JET		0.00	01/07/28			15					_
FLOW CNC Waterje	et	Dwg Rev: Prog Rev:		0.00	,								
110	(QC2- Inspect pārts off	machine FAI/FAIB	0.00) 11/07/28			15					
QC Quality Control		Memo		0.00	5 1/ 1/ 8								
120	(QC8- Inspect parts - s	econd check	0.00				N/		,	67	18[/
QC		Memo		0.00						<u>'</u>			•

W/O:			WC	ORK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
		esolution:		•					
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC	Description of NC Section A Initial Corrective Action Action Description			Verifi	cation	Approval	Approval
אלוב	SILF	Section A	Initial Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector	
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Work Order ID 71978

Thursday, July 14, 2011 3:11:44 PM



Page 2

Item ID:

D3531-3

Accept

Setup Start



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

7/14/2011 Required Date: 7/22/2011

QC:

Start Qty: 6.00

Req'd Qty: 6:00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____ Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ **Run Hours**

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3530

0.00

0.00

0.00

150

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

S w/18/02

W/O:			W	/ORK ORDER CHANGI	ES					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	,	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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				No.						
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Y	es N	o DQA:		Date:	
		esolution:								
NCR:	:	V	WORK OR	DER NON-CONFORMA	NCE (N	ICR)				
DATE	STEP	Description of NC			on B		Verifica	tion	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section		Chief Eng	QC Inspector
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Work Order ID 71978

Thursday, July 14, 2011 3:11:44 PM



Page 3

Item ID:

D3531-3

Accept



Setup Start



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

Required Date: 7/22/2011

7/14/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Stop

Sequence ID/ **Work Center ID**

160

HandFinish Hand Finishing Memo

Chemical Conversion Coat per QSI005 4.1

Run Hours

Set Up/

0.00

0.00

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Packaging

W/O:			WC	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	: Yes N	o DQ	A:	_ Date: _	
	R	esolution:	Disposition	າ:	QA: I	WC Clos	sed:		Date:	
NCR:			WORK ORDI	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Corrective Action						/erification Approva		Approval
DAIL	SILF	Section A	Initial Chief Eng			Sign & Section		on C	Chief Eng	QC Inspector
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Work Order ID 71978

Thursday, July 14, 2011 3:11:44 PM



Page 4

Item ID:

D3531-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

7/14/2011

Start Qty: 6.00

Required Date: 7/22/2011 Req'd Qty: 6.00

Cust Item ID:

Date:

Date:

Tool # Plan

Code

Customer:

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:

Date:

Tooling:

SPC (Y/N):

Tool ID

Run

Stop

Reject

Number



Sequence ID/

Work Center ID

190

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

Accept

Qty

Start



Insp.

Stamp

Quality Control

0.00

Reject

Qty

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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					1					
Part No	·	PAR #:	Fault Ca	tegory:	NCR:	Yes N	No DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: I	VC Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			tion B		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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		š								
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Picklist Print

Thursday, July 14, 2011 3:11:52 PM

Work Order ID: 71978

Parent Item:

D3531-3

Parent Item Name: Bracket Front Plate



Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	105.5000	0.1313	0.829263			

6061-T6 .040 Sheet

Location	Loc Qty	Loc Code
MAT021	105.5	
113004	9.5	
117653	96	

110 80 11/07/28

Dail Aci	ospace	Ltu								
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	B	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			····							
Part No		PAR #:	Fault Cat	tegory:	_ NCR: Y	es N	o DQ	A:	Date: _	<u>. </u>
Resolution: Disposition: QA: N/C Closed: Date							Date: _			
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Si	gn & ate	Verific Secti		Approval Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	
Description: Bracket Front Plate	Part Number:	D3531-3
Inspection Dwg: D3531 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	e 13 1			RAZL	News
3.72	+/-0.030	3.730			· 1/3	
0.37	+/-0.030	.369			RAZO	lem
2.840	+/-0.010	2.845			. (1	
0.88	+/-0.030	.887			Ч	
3.50	+/-0.030	3.498	/		ι 1	
4.67	+/-0.030	4.671			И	Vem
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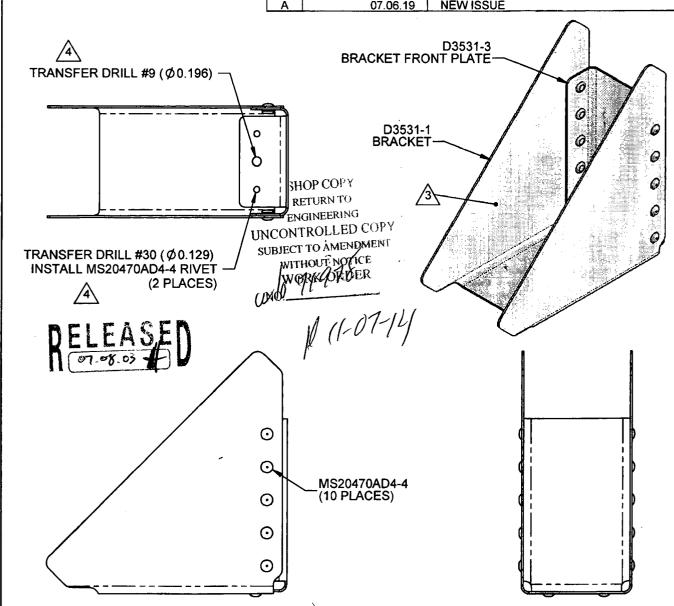
Measured by:	A -	Audited by:	MM	Prototype Approval:	N/A
Date:	11/07/28	Date:	11 07 78	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.10.15	New Issue	KJ/EC/DD
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	. Johass										
W/O:	N/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE By Date					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Cate	egory:	_ NCI	R: Yes	No DQ	DQA: Date:			
Resolution:			Disposition: QA			: N/C Cld	sed:	Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section			Verific			Approval	Approval	
		Section A	Initial Chief Eng			Date	Sign & Section C		Chief Eng	QC inspector	
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DESIG	B	CB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHEC	KED	APPROVED	D3531	REV. A SHEET 1 OF 3
DATE	07.0	06.19	BRACKET ASSEMBLY	SCALE 1:2
REV		DATE	DESCRIPTION	
INL V	ļ	DAIL	DESCRIPTION_	



D3531-041 BRACKET ASSEMBLY

NOTES:

1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS

- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET
- ASSEMBLY, WHERE INDICATED

 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE **BEFORE FINISHING**

PARTS LIST

QTY.	P/N	DESCRIPTION
Х	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

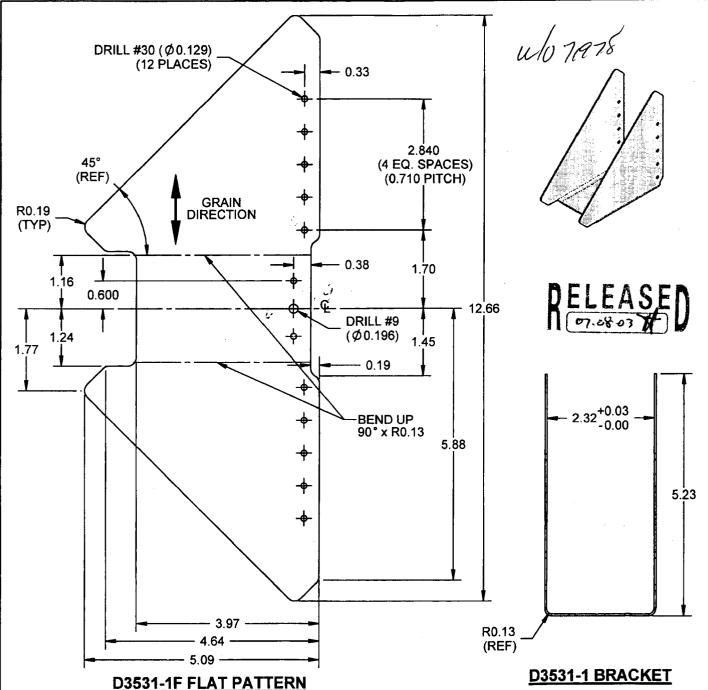
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W/O:			WC	RK ORDER CHANG	ES		<u> </u>			
DATE	STEP	PRO	OCEDURE CHAI	NGE	By Date			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCF	: Yes I	No DQ	A :	_ Date: _	
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DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval	Approval
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CB DESIGN	DRAWN BY	DART AEROSPACI HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	D3531	REV. A SHEET 2 OF 3
DATE 07.0	06.19	BRACKET ASSEMBLY	SCALE 1:2



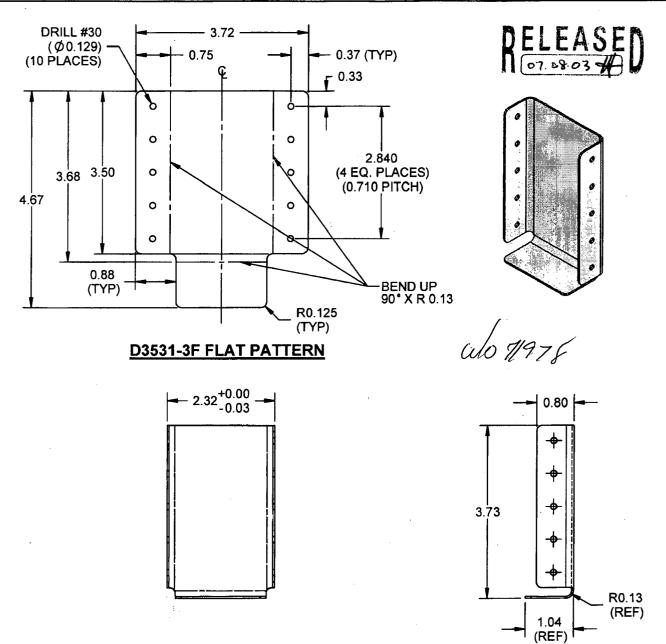
- NOTES:
 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR
 AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT &

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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CHECKED	APPROVED	D3531	REV. A SHEET 3 OF 3
DATE 07.	06.19	BRACKET ASSEMBLY	SCALE 1:2



D3531-3 BRACKET FRONT PLATE

- NOTES:

 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)

 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

 3) TOLERANCES ARE PER INJURIES UNITED MISS NOTED

- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX 6) PART IS SYMMETRIC ABOUT &

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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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